

Date: Monday, 4/10/2006 11:13:50 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLOWER MOTOR SUPPORT  
 Job Number : 26611  
 Estimate Number : 12309  
 P.O. Number : *N/A* Part Number : D3471043  
 This Issue : 4/10/2006 S.O. No. : *N/A* Drawing Number : D3471 REV.A  
 Prsht Rev. : NC Project Number : *N/A*  
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : 26268 Material : *N/A*  
 Due Date : 4/28/2006 Qty: 1 Um: Each  
 Written By : *See comment below*  
 Checked & Approved By : *06.04.10*  
 Comment : est rev A 06.03.02 New issue EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MS3584216 CLAMP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part number Description Batch  
 1 MS35842-16 CLAMP *M 100261 1A*

*FF 06.04.26 10*

2.0 MS20427M44 RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

pick:

Qty Part number Description Batch  
 3 MS20427M4-4 Rivet *7100393*

*FF 06.04.26 10*

3.0 D34713 SUPPORT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part number Description Batch  
 1 D3471-3 Support *B26126*

*FF 06.04-26 10*

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3471

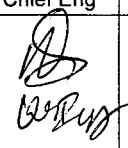
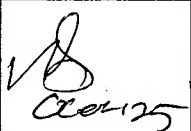

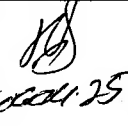
*FF 06.04-27 10*

*FF 06.04-27*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<del>Step</del> 06.04.26	4	one clamp screwp		destroy & replace	FF 06.04.26			

NOTE: Date & initial all entries

Date: Monday, 4/10/2006 11:13:50 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26611

Part Number: D3471043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*AS 06/04/27 (10)*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*AS 06/04/27 (10)*

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*AS 06/04/28 (10)*

Job Completion



*u 06.04.28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

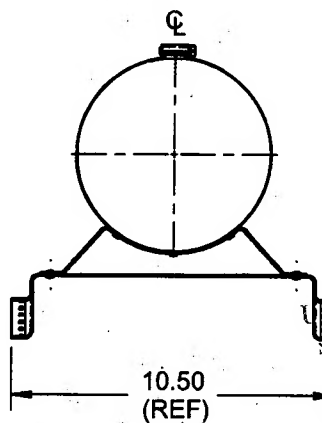
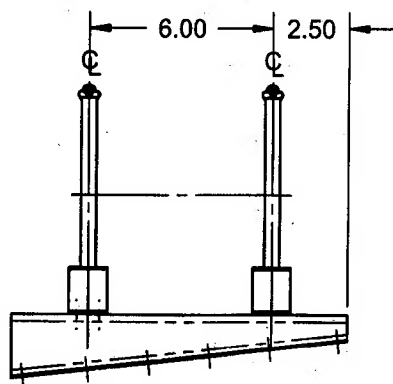
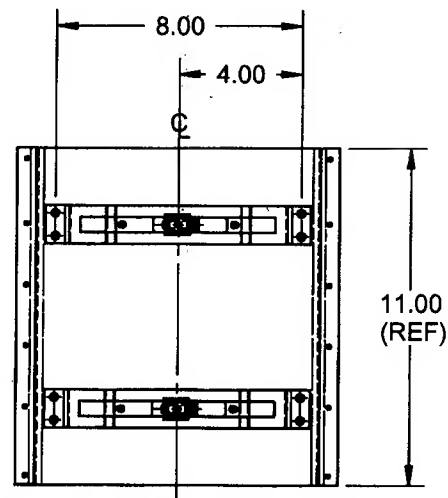
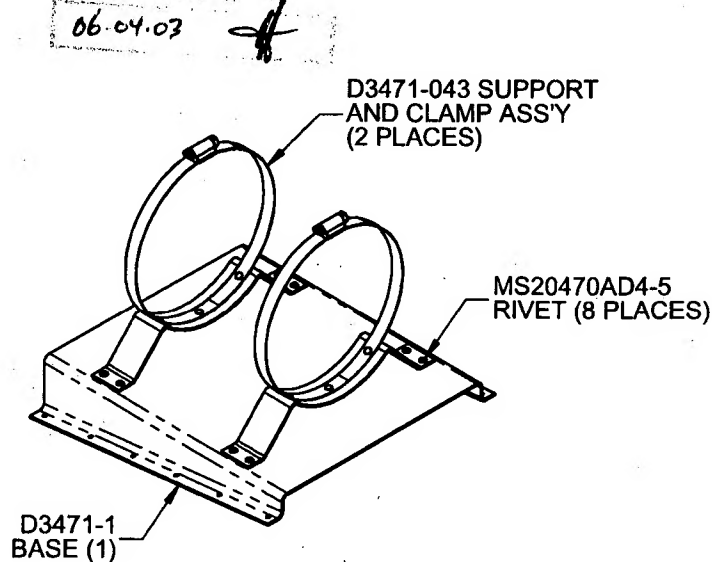
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN B	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3471</b>	REV. A SHEET 1 OF 5
DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SCALE 1:6
A	05.12.21	NEW ISSUE	



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WORK ORDER  
NO 26611

### D3471-041 BLOWER MOTOR SUPPORT

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3471-041	BLOWER MOTOR SUPPORT
2	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-1	BASE
8	MS20470AD4-5	RIVET

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CHECKED H	APPROVED H	DRAWING NO. D3471	REV. A
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SHEET 2 OF 5 SCALE 1:3

06.04.03

LOCATE AND TRANSFER DRILL  
#30 ( $\varnothing 0.129$ ) THRU HOLE FROM  
D3471-3 TO MS35842-16 CLAMP  
AND C'SINK  $\varnothing 0.230 \times 100^\circ$   
(3 PLACES)

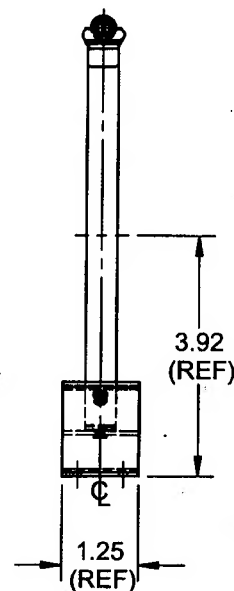
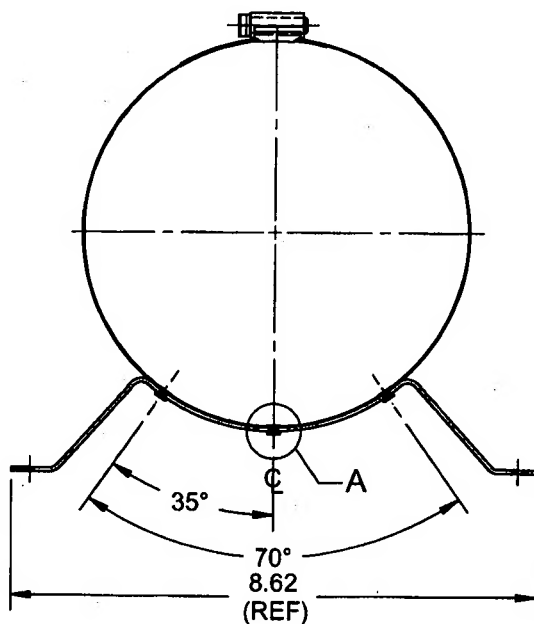


**DETAIL A: COUNTERSINK HOLES**  
(RIVET NOT SHOWN FOR CLARITY)  
SCALE 1:1

MS20427M4-4 RIVET  
(3 PLACES)

MS35842-16  
CLAMP

D3471-3  
SUPPORT



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### D3471-043 SUPPORT & CLAMP ASS'Y

#### NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-3	SUPPORT
3	MS20427M-4	RIVET
1	MS35842-16	CLAMP

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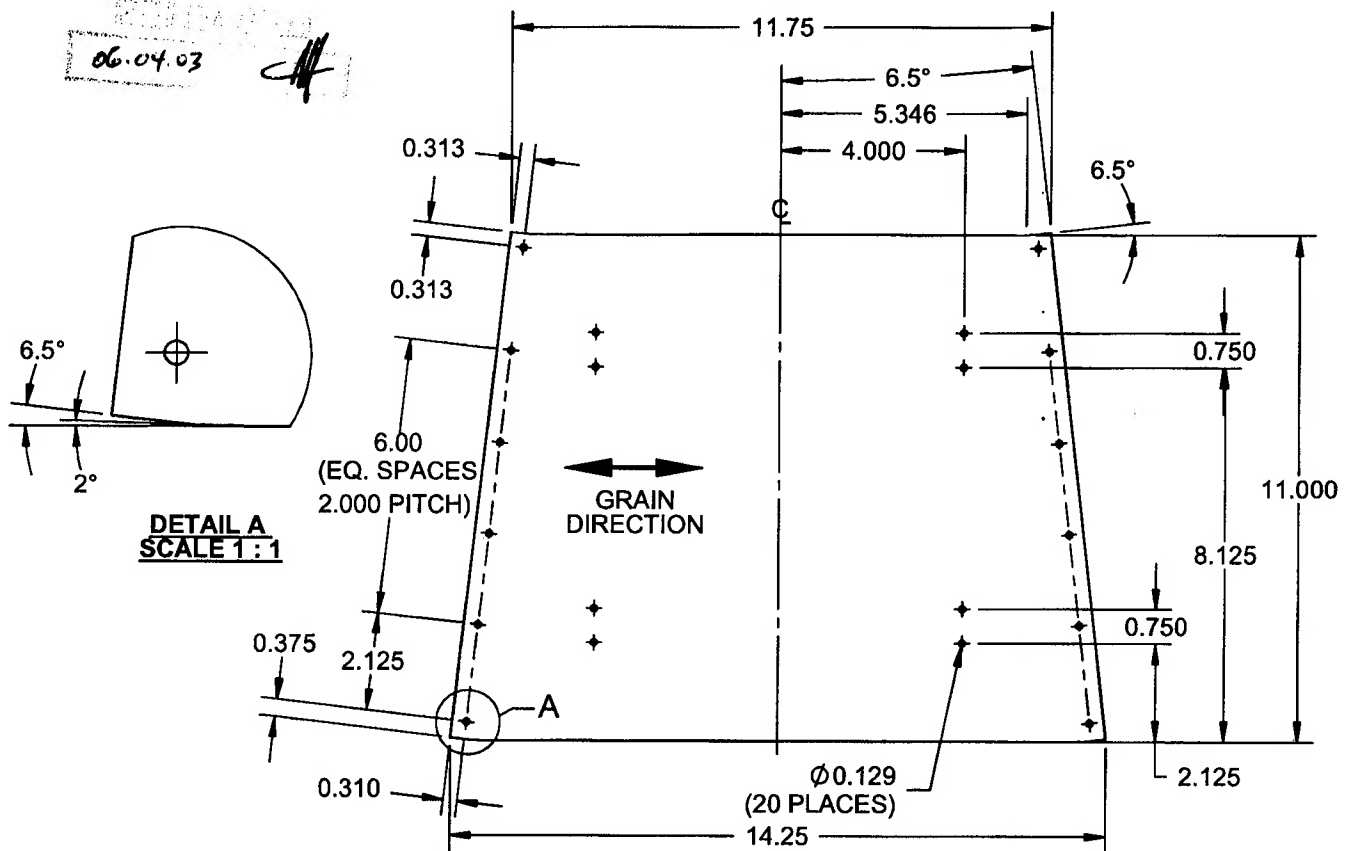
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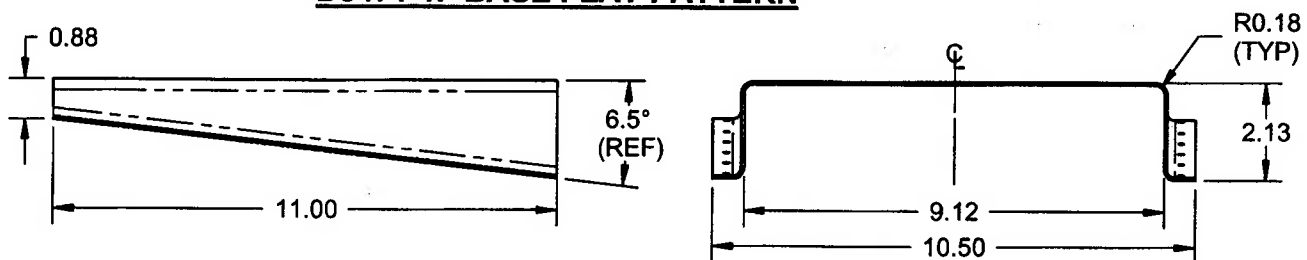


**DART**

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DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SCALE 1:4



### D3471-1F BASE FLAT PATTERN



### D3471-1 BASE BENDING DETAIL

#### NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

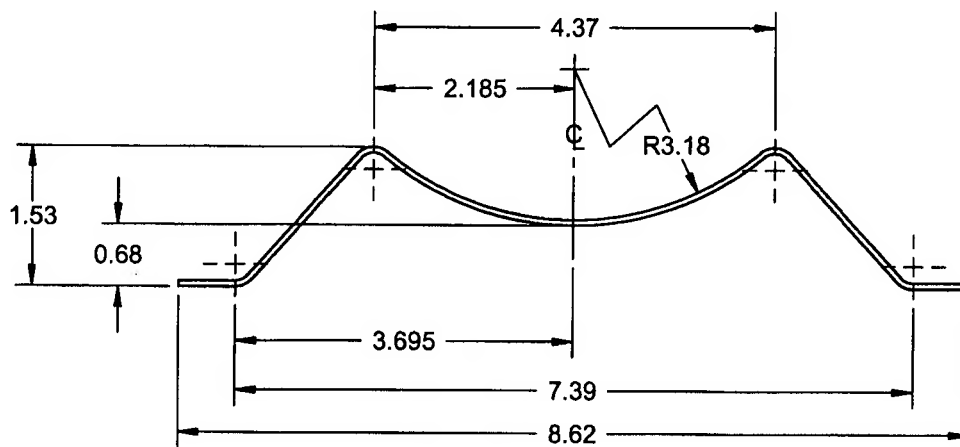
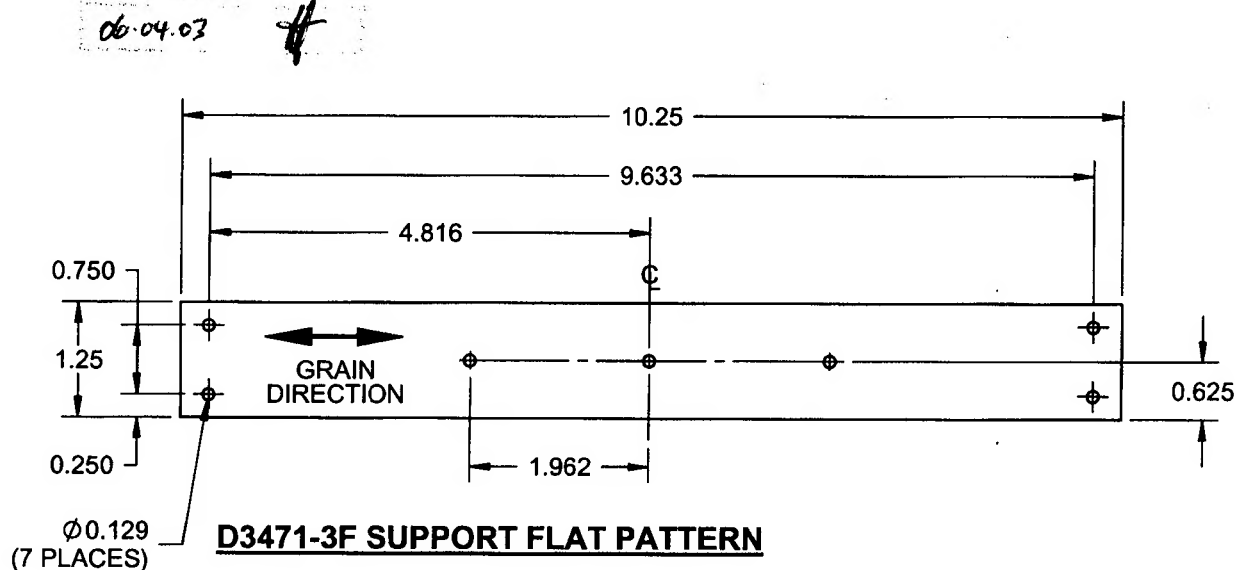
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DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:2
		SHEET 4 OF 5	



### **D3471-3 SUPPORT BENDING DETAIL**

#### **NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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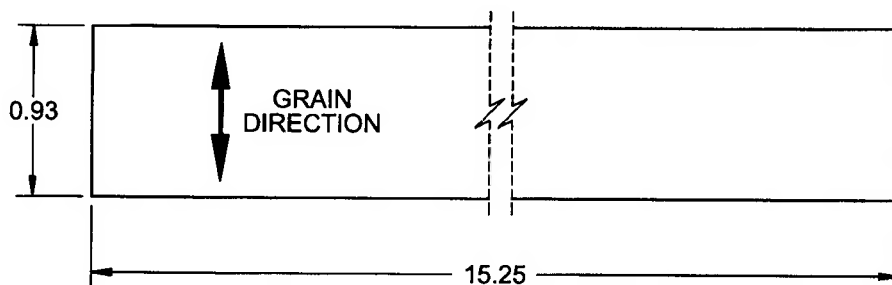
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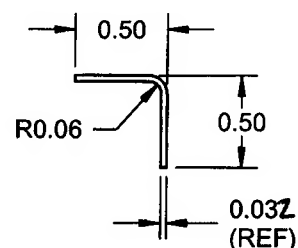


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DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SCALE 1:1

06.04.03 *[Signature]*



**D3471-5F STIFFENER FLAT PATTERN**



**D3471-5 STIFFENER BENDING DETAIL**

**D3471-5 STIFFENER**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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